Work Order ID 71836

Page 1

Wednesday, July 13, 2011 10:18:56 AM Item ID: D3492-1 Accept Setup Start **Revision ID:** Stop Item Name: Plug · **Start Qty: 100.00** Start Date: 7/14/2011 **Cust Item ID:** Req'd Qty: 100.00 Required Date: 7/28/2011 **Customer:** Reference: Start Run Date: 11-07-17 Tooling: Process Plan: MC **Approvals:** Date: Stop QC: Date:______ SPC (Y/N): Date: Sequence ID/ Operation Reject Tool ID Tool # Plan Set Up/ Accept Reject Insp. Description Work Center ID Code Qty Stamp **Run Hours** Oty Number Draw Nbr **Revision Nbr** D3492 D 100 0.00 Hardinge CNC LATHE SMALL 0.00 Hardinge Memo 1-Turn as per Folio FA633 & Dwg D3492 Dwg Rev: Hardinge CNC Lathe Small Folio Rev: NJ QC2- Inspect parts off machine FAI/FAIB 110 0.00 0.00 Memo Quality Control 5/11/7/26 120 QC8- Inspect parts - second check 0.00 X 11-07-26 QC 0.00 Memo

Quality Control

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W/O:			V	VORK ORDER CHANG	GES					
DATE	STEP	PRO	OCEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Ca	tegory:	NCI	R: Yes I	No DQ	A:	Date: _	
	Re	esolution:	Disposit	ion:	QA:	N/C Clo	sed:		Date: _	
NCR:			WORK OR	DER NON-CONFORM	IANCE	(NCR)			
DATE	STEP	Description of NC			ection B	C: 0	Verific	cation	Approval	Approval
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Work Order ID 71836

Page 2

Item ID:

D3492-1

Wednesday, July 13, 2011 10:18:56 AM

Accept



Setup Start

Stop



Revision ID:

Item Name: Plug

Start Date:

7/14/2011

Start Qty: 100.00

Req'd Oty: 100.00

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date: _____

Tooling:

Date:

Tool # Plan

Code

Run

Start

Stop



Required Date: 7/28/2011

QC:

Date: _____

SPC (Y/N):

Date:

Qty

Accept

Reject

Qty

Reject Number

Insp. Stamp

Sequence ID/ **Work Center ID**

150

HandFinish

Hand Finishing

Operation Description

Chemical Conversion Coat per QSI005 4.1

Run Hours

0.00

Set Up/

0.00

160

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

M117745.

QC3- Inspect Part Finish

Memo

Memo

Memo

(Flat End Only)

OVEN TEMPERATI

START TIME:

FINISH TIME:

0.00

0.00

0.00

0.00

100 cp St 11-7-26.

170

Quality Control

100 d Mulos 27

										
W/O:	-		WC	RK ORDER CHANGI	ES		.	_		
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DATE STEP		Description of NC	Corrective Action Section				Verific	ation	Approval	Approval
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Work Order ID 71836

Wednesday, July 13, 2011 10:18:56 AM



Page 3

Item ID:

Revision ID:

D3492-1

Item Name: Plug

Start Date:

7/14/2011

Start Qty: 100.00

Accept

Setup Start

Stop



Required Date: 7/28/2011

Req'd Qty: 100.00

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Date: _____

Tooling:

SPC (Y/N):

Date:

Date:

Tool # Plan

Run Start

Reject



Stop

Sequence ID/

Work Center ID

180

Packaging

Packaging

Operation Description

QC:

Identify as per dwg & Stock Location:

Run Hours

Set Up/

0.00

0.00

Tool ID

Code

Qty

Accept

Qty

Reject Number

Insp.

Stamp

190

OC

Quality Control

OC21- Final Inspection - Work Order Release

Memo

Memo

0.00

0.00

		-								
W/O:			WC	RK ORDER CHAN	GES					
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	Fault Cate	gory:	NCR:	Yes N	lo DQ	A:	Date:	
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DATE	STEP	Description of NC Corrective Action			Section B Veri			cation Approval		Approval
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Picklist Print

Wednesday, July 13, 2011 10:18:53 AM

Work Order ID: 71836

Parent Item: D3492-1

Parent Item Name: Plug



Start Date: 7/14/2011

Start Qty: 100.00

Required Date: 7/28/2011

Page 1

Required Qty: 100.00

Comments:

IPP Rev:A 11.04.19 per dwg revC DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.625		Purchased	No			100	f	57.4900	0.0625	6.578947	1//	1/2	<i>)</i>

6061-T6 Round Bar .625"

Location	Loc Qty	Loc Code
MAT012	57.49	
14.7284	47.4	
117481	10.09	

SPA

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W/O:			WO	RK ORDER CHANG	ES	· ·	· .		
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cateç	Jory:	_ NCR: Yes	No DQA	\ :	Date: _	
	Res	olution:	Disposition):	_ QA: N/C Cl	osed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)			
DATE	STEP Description of NC					Verific	ation	Approval	Approval
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DART AEROSPACE LTD	Work Order:	X1836
Description: Plug	Part Number:	D3492-1
Inspection Dwg: D3492 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Х	First Article			Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.060	+/-0.005	.06/		-	212	
0.060	+/-0.005	-060				
Ø0.394	+/-0.010	. 375	///		,	
Ø0.625	+/-0.010	0,625				
0.090	+0.000/-0.002	980				
0.500	+/-0.010	. 500				
2.055	+0.000/-0-002					
0.050 x 20°	+/-0.010	050XJg				
.050) +,000/002	.0495				
			,			,

Measured by:	Z)		Audited by:	ント	Prototype Approval:	N/A
Date:	11)	7/26	Date:	11-07-26	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	06.06.02	New Issue P/O D3492-041	KJ/JLM	
В	06.10.16	Ø0.625 was Ø0.500	KJ/JLM	
C	07.11.23	Tolerances revised	KJ/EC/DD) A	
D	08.06.19	0.050 x 20° dimension added	KJ/DD of	7

Dart Ae	rospace	e Ltd	*						-
W/O:			WO	RK ORDER CHANGE	ES				
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cated	gory:	NCR: Yes	No DQA	.:	_ Date: _	
	·R	esolution:	Disposition	1: <u> </u>	QA: N/C C	losed:		Date: _	
NCR:			WORK ORDI	R NON-CONFORMA	NCE (NC	₹)			
DATE	CTED	Description of NC		Corrective Action Section		Verifica	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Section		Chief Eng	QC Inspector
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-NAS1611 O-RING (SEE TABLE) D3492-XX PLUG (SEE TABLE)-

D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	-051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		Х					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						Х	D3492-053	PLUG ASSEMBLY
<u> </u>	<u> </u>						504004	Tarties .
1							D3492-1	PLUG
	1_						D3492-3	PLUG
		1			L		D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
							L	
		1					NAS1611-005	O-RING
			1				NAS1611-007	O-RING
1							NAS1611-010	O-RING
						1	NAS1611-012	O-RING
	1						NAS1611-013	O-RING
					1		NAS1611-015	O-RING
				1			NAS1611-016	O-RING

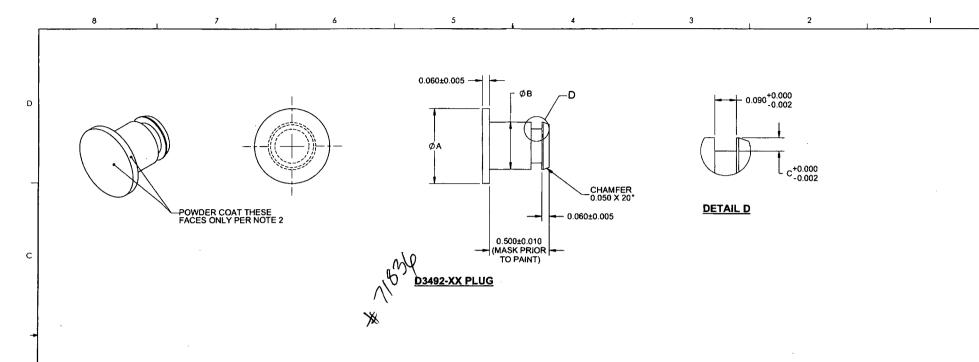
NOTES: 1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

D	INCORPORATED DEO D3492-C-1. SHT 2 DIM C FOR -1 WAS 0.055. (SEE CAR11-048)	SLA	11.05.24
Ç	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
В	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
Α	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE

			1 0, Dille			
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
DRAWN	AS					
CHECKED	ki	DRAWING NO.	REV. D			
MFG. APPR.	JER	D3492	SHEET 1 OF 2			
APPROVED	VA	TITLE	SCALE			
DE APPR.	1	PLUG	2:1			
DATE 11.	05.24	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT BY SPEVALE AND COMPENSION AND AS SUPPLED ON THE OPPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR OUTPED ON COMMUNICATION TO ANY OTHER PERSON WITHOUT				

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Resolution:			Disposition	Disposition: Q			QA: N/C Closed: Date			
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D3492-XX PLUG MACHINING DETAILS

P/N	A	В	_ C	MATERIAL SPEC
D3492-1.	0.625	0.394	0.050	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500
D3492-9	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.850	0.664	0.045	M6061T6R0.875
03492-13	0.750	0.510	0.045	M6061T6R0.750

NOTES:
1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-208/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: N/A 7) WEIGHT: N/A

DESIGN	PH	DART AEROSPACE LTD						
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA						
CHECKED	<u>k</u>	DRAWING NO.	REV. D					
MFG. APPR.	JESA	D3492	SHEET 2 OF 2					
APPROVED	\\d	TITLE	SCALE					
DE APPR.	#	PLUG	4;1					
DATE 11.0	5.24	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS COCAMON IS PROVIDED CONTROL THAT IT IS NOT TO BE USED FOR MY PURPOSE OR COPED OR COMMANCATED TO MY OTHER PERSON WITHOUT WITHER PERSON FIND MAY DAY DAY DAY DE TO MY OTHER PERSON WITHOUT WITHER PERSON FIND MY DAY DAY DAY DAY DAY DAY WITHER PERSON FIND MY DAY DAY DAY DAY DAY DAY WITHER PERSON FIND MY DAY DAY DAY DAY DAY DAY WITHER PERSON FIND MY DAY DAY DAY DAY DAY WITHER PERSON FIND MY DAY DAY DAY DAY WITHER PERSON FIND MY DAY DAY DAY WITHER PERSON FIND MY DAY DAY DAY WITHER PERSON FIND MY DAY WITH PERS						

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Part No:		PAR #:	PAR #: Fault Category:				NCR: Yes No DQA: Date:						
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DATE	STEP	Description of NC			ection B		Verificat	ion	Approval	Approval			
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng) 	Sign & Date	Section C		Chief Eng	QC Inspector			
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